

Work Order ID 111117

Thursday, January 09, 2014 11:28:54 AM

111117

Page 1

Item ID: PB67-43001-57

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stabilizer Arm

Start Date: 1/8/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: UMFDate: 14-01-09

Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-57

C

100

Weld per dwg A/R Aluminum rod Batch: 125091 0.00
Large Fab***100***

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg PB67-43001

CP 14-01-302*

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

14-01-20DAS
9
9-89

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

CP 14-01-3014-01-20DAS
9
9-89

Work Order ID 111117

Thursday, January 09, 2014 11:28:54 AM

111117

Page 2

Item ID: PB67-43001-57 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stabilizer Arm
Start Date: 1/8/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/24/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- line drill -107 and -109 using existing pilot hole of -107 as per dwg 2- install spring pin								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Green Sandtex(Ref:4.3.5.8) per OSI00543	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:35 328 OVEN TEMPERATURE: FINISH TIME: 12:05								

PC 14.01.20 24

14.01.20

2 φ. 14-2-3

DAS
9
9-89

DAS
34
9-89

Thursday, January 09, 2014 11:28:54 AM

Page 3

MLJ 14-02-04

N 14-02-04

Picklist Print

Thursday, January 09, 2014 11:28:53 AM

Page 1

Work Order ID: 111117

Parent Item: PB67-43001-57

Parent Item Name: Stabilizer Arm

Start Date: 1/8/2014

Required Date: 1/24/2014

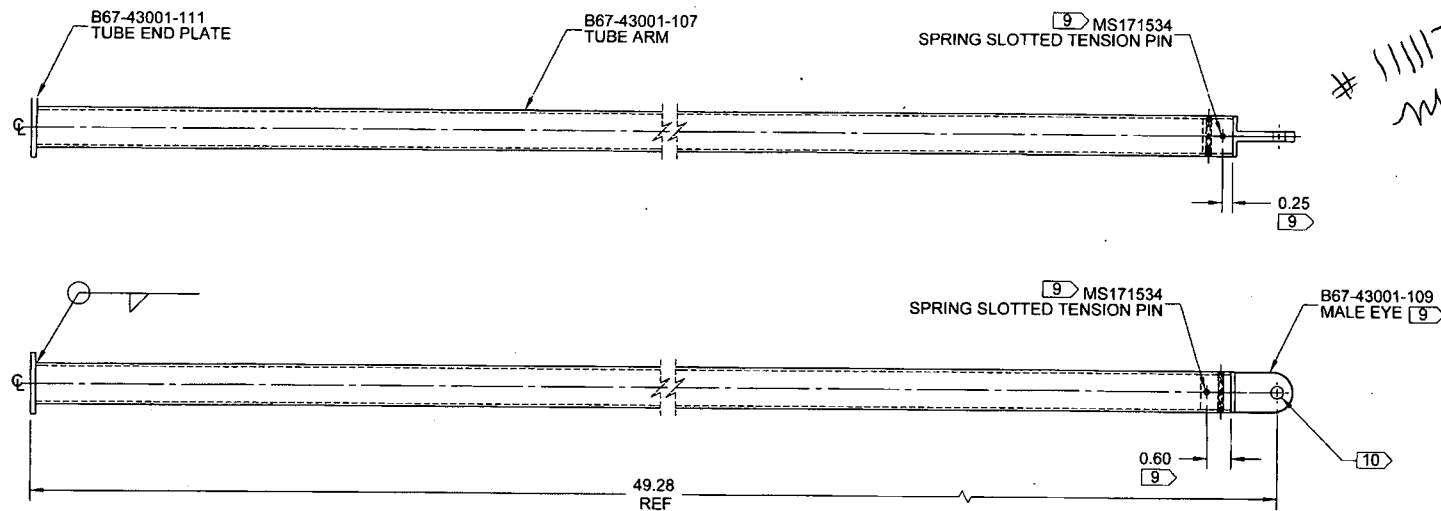
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-107 Tube Arm		Manufactured	No			100	Each	3.0000	1	1	<i>Cpl</i>		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		3							
				100014 = 1		2							
				62130 = 1		1							
PB67-43001-111 Tube End Plate		Manufactured	No			100	Each	2.0000	1	1	<i>Cpl</i>		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		2							
				90894		2							
* 240-107 SPRING SLOTTED PIN		Purchased	No			130	Each	16.0000	2	2	<i>Cpl</i>		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST382		16							
				124060 = 2		16							
PB67-43001-109 Male Eye		Manufactured	No			130	Each	2.0000	1	1	<i>Cpl</i>		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		2							
				90893		2							

ITEM	QTY -57	P/N	DESCRIPTION
1	X	B67-43001-57	STABILIZER ARM
3	1	B67-43001-107	TUBE ARM
4	1	B67-43001-109	MALE EYE
5	1	B67-43001-111	TUBE END PLATE
7	2	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



B67-43001-57 STABILIZER ARM

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.00 lbs
- 8) WELDING: PER QSI 004
- 9) PRIOR TO POWDER COAT, ALIGN B67-43001-109 ON B67-43001-107 AS SHOWN AND DRILL QTY.(2) ϕ 0.129 HOLES THROUGH BOTH PARTS AND FASTEN B67-43001-109 TO B67-43001-107 USING QTY.(2) MS171534 SPRING SLOTTED PIN
- 10) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.25	
REV.	DESCRIPTION		BY	DATE	
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED	JS		DRAWING NO.	REV. C	
MFG. APPR.	MD		B67-43001-57	SHEET 1 OF 1	
APPROVED	MD		TITLE	SCALE	
DE APPR.	N/A	STABILIZER ARM	NTS		
DATE	09.06.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--	--